

Date: Thursday, 5/4/2006 11:13:51 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLOWER MOTOR SUPPORT
<b>Job Number</b> : 26955	
<b>Estimate Number</b> : 12311	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D3471041
<b>This Issue</b> : 5/4/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D3471 REV.A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 26610	<b>Material</b> : N/A
<b>Written By</b> : <i>See Comment Below</i>	<b>Due Date</b> : 5/28/2006 <b>Qty:</b> <i>2</i> <b>Um:</b> <i>8</i> <b>Each</b>
<b>Checked &amp; Approved By</b> : <i>06.05.05</i>	
<b>Comment</b> : est rev A 06.03.02 New issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D3471043	SUPPORT AND CLAMP ASSEMBLY
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**Comment:** Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

qty	part number	description	batch
2	D3471-043	CLAMP ASS'Y	<i>B26989</i>

*FF 06.05.17 2*

2.0	MS20470AD45	Rivet, Universal Head
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**Comment:** Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

qty	part number	description	batch
8	MS20470AD4-5	Rivet	<i>1718461</i>

*FF 06.05.17 2*

3.0	D34711	BASE
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

BASE

*B 26612**FF 06.05.17 2*

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Assemble as per dwg D3471

*FF 06.05.17 2*

5.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

*B 06/05/18 2*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DP Date: 02/05/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 5/4/2006 11:13:51 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR SUPPORT

Job Number: 26955

Part Number: D3471041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: 57356

*P 4/5/18 (2)*

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

*06/05/19 (2)*

Job Completion



*U 06.05.19*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

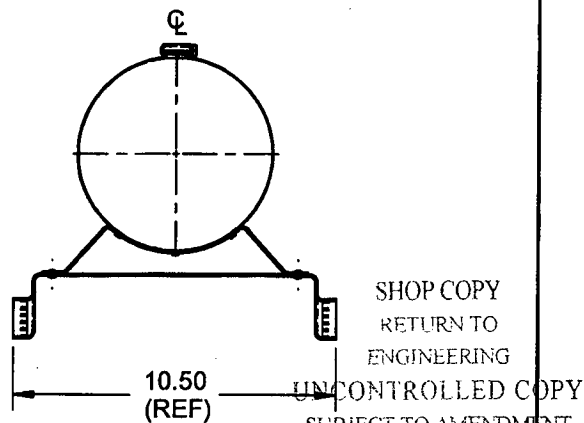
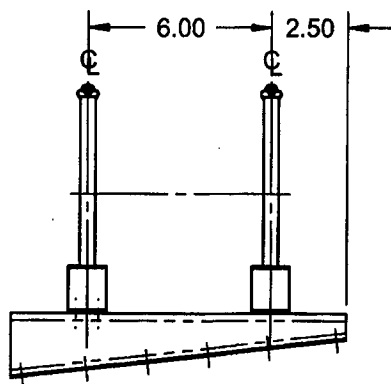
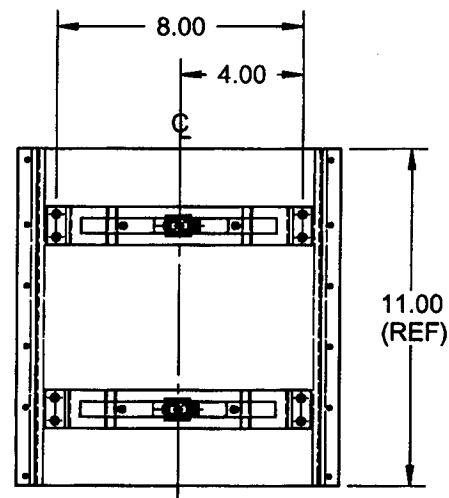
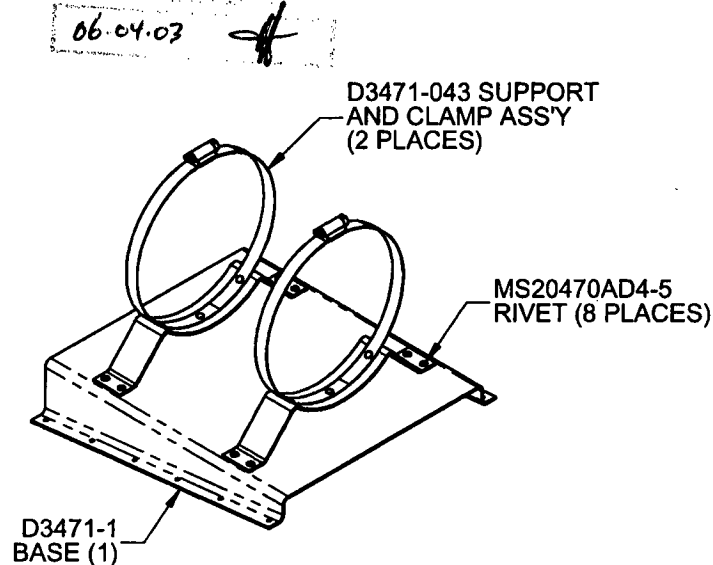
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN B	DRAWN BY B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3471</b>	REV. A SHEET 1 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:6
A	05.12.21	NEW ISSUE	



### D3471-041 BLOWER MOTOR SUPPORT

#### NOTES:

- 1) IDENTIFY WITH DART P/N D3471-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3471-041	BLOWER MOTOR SUPPORT
2	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-1	BASE
8	MS20470AD4-5	RIVET

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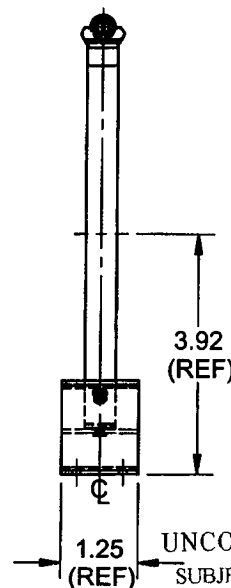
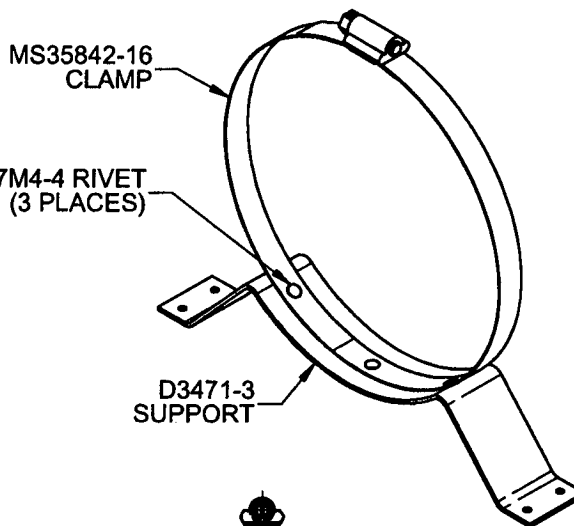
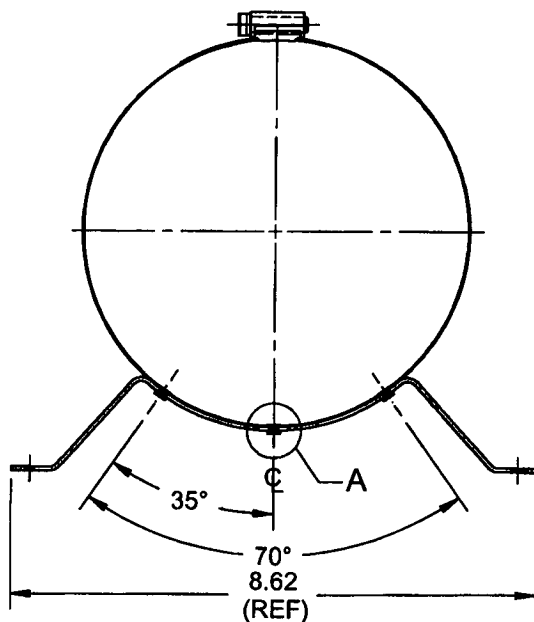
DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3471	REV. A SHEET 2 OF 5
DATE 05.12.21		TITLE BLOWER MOTOR SUPPORT	SCALE 1:3

06.04.03

LOCATE AND TRANSFER DRILL  
#30 ( $\varnothing 0.129$ ) THRU HOLE FROM  
D3471-3 TO MS35842-16 CLAMP  
AND C'SINK  $\varnothing 0.230 \times 100^\circ$   
(3 PLACES)



**DETAIL A: COUNTERSINK HOLES**  
(RIVET NOT SHOWN FOR CLARITY)  
SCALE 1:1



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### D3471-043 SUPPORT & CLAMP ASS'Y

#### NOTES:

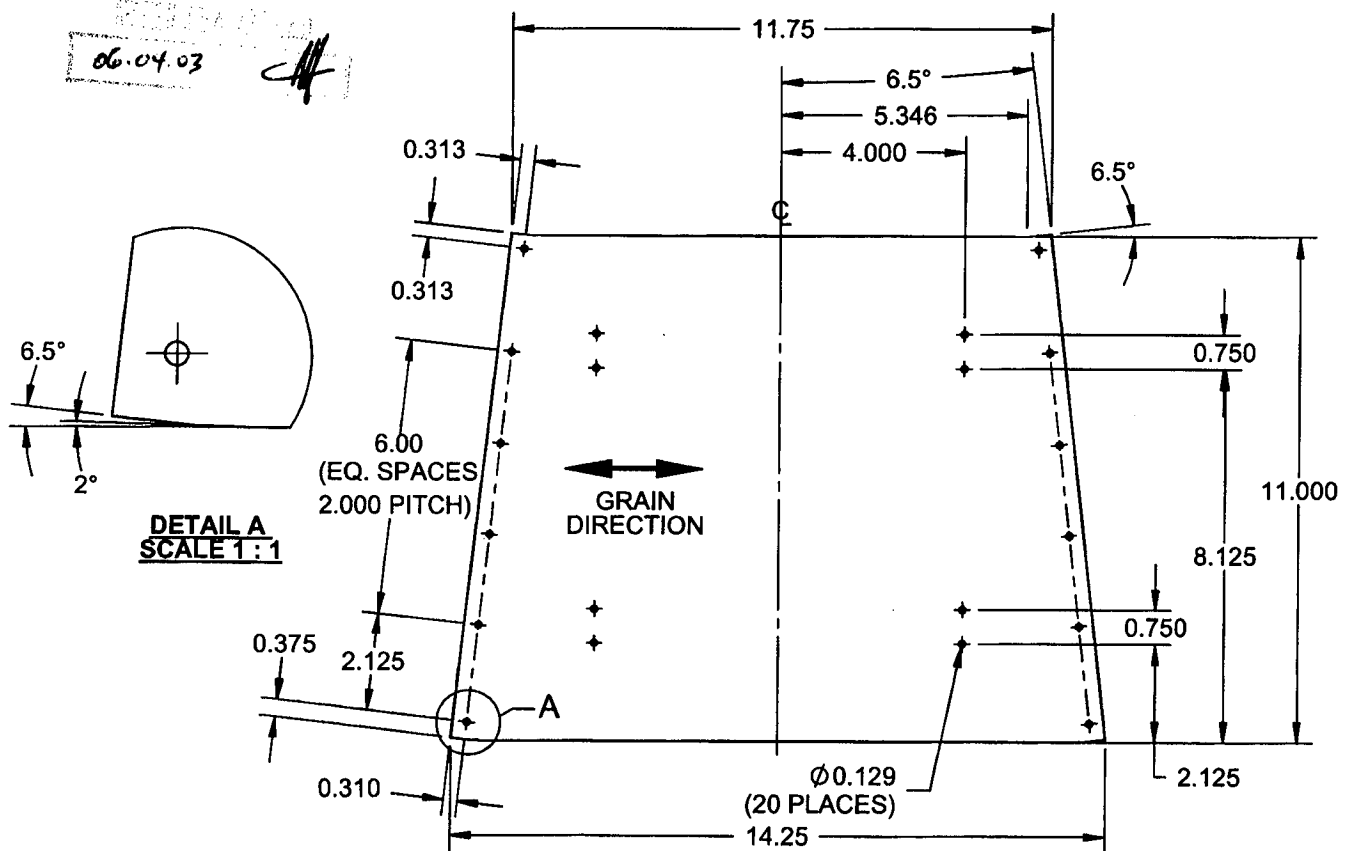
- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3471-043	SUPPORT AND CLAMP ASSEMBLY
1	D3471-3	SUPPORT
3	MS20427M-4	RIVET
1	MS35842-16	CLAMP

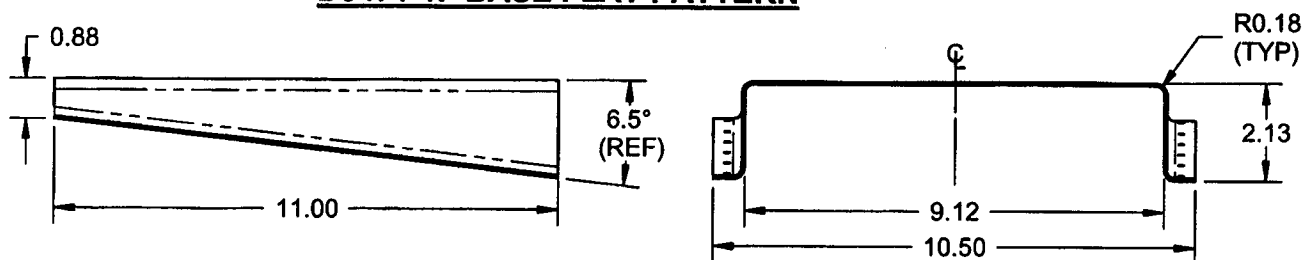
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3471</b>	REV. A SHEET 3 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	
		SCALE 1:4	



### D3471-1F BASE FLAT PATTERN



**D3471-1 BASE BENDING DETAIL**

**NOTES:**

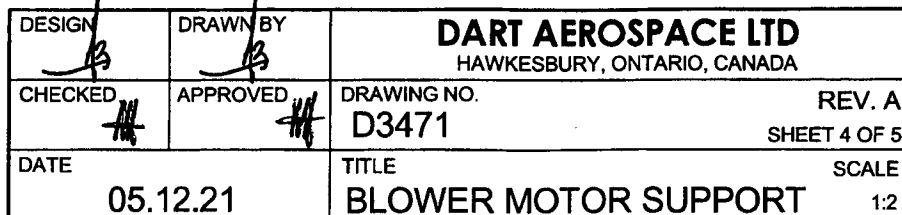
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063" THICK) UNCOATED  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063) SUB  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) PART IS SYMMETRICAL ABOUT CENTER LINE  
4) ALL DIMENSIONS ARE IN INCHES  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010 NO

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10.25

9.633

4.816

0.750

1.25

0.250

GRAIN DIRECTION

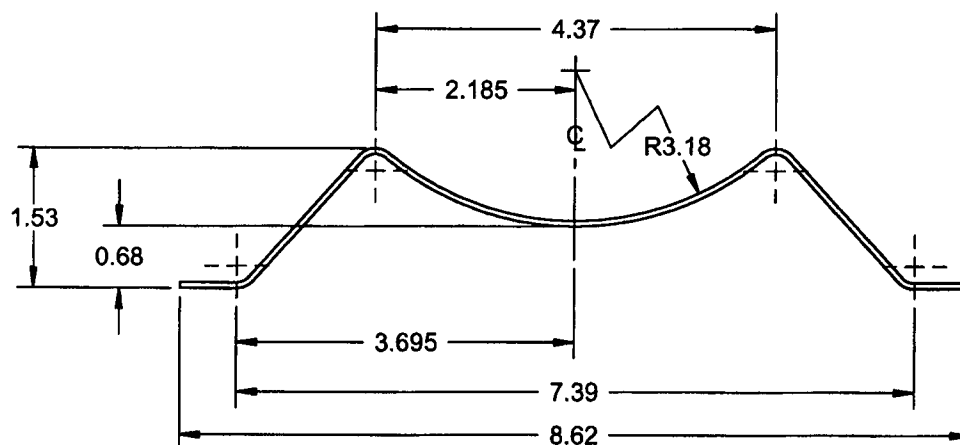
1.962

0.625

Ø 0.129  
(7 PLACES)

**D3471-3F SUPPORT FLAT PATTERN**

### D3471-3F SUPPORT FLAT PATTERN



### D3471-3 SUPPORT BENDING DETAIL

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.063 THICK)  
PER AMS-QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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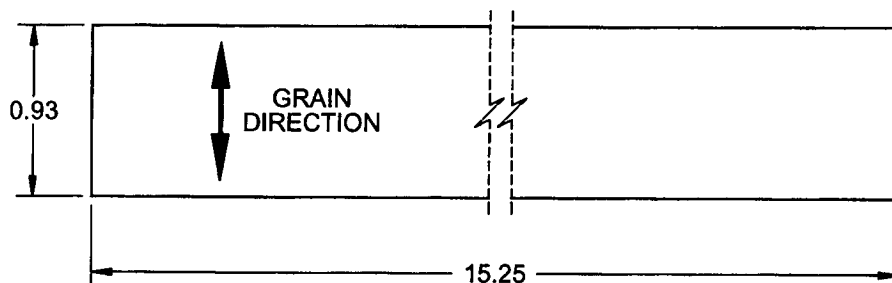
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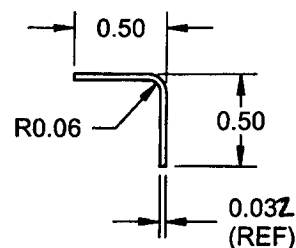


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3471</b>	REV. A SHEET 5 OF 5
DATE <b>05.12.21</b>		TITLE <b>BLOWER MOTOR SUPPORT</b>	SCALE 1:1

06.04.03 *[Signature]*



**D3471-5F STIFFENER FLAT PATTERN**



**D3471-5 STIFFENER BENDING DETAIL**

**D3471-5 STIFFENER**

**NOTES:**

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET (0.032" THICK)  
PER QQ-A-250/4 OR AMS 4037  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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